

# Work Order ID 74591

Monday, October 03, 2011 3:57:25 PM

Page 1

Item ID: D3793-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 10/3/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-10-04 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3793

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793

☐ Dwg Rev: A

☐ Prog Rev: 1

☐ 2-

Deburr if necessary

11-10-6

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-10-6

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5/10/07

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_


Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00				(13)			
Brake NC	<b>Memo</b>	0.00							
Brake NC	1-Deburr if necessary <input type="checkbox"/> 2-Form on Brake as per Dwg D3793 using Jigs <input type="checkbox"/> 3-Form Joggle on brake using Jig as per Dwg D3793								
					SB 11/10/14				
140 	QC5- Inspect part completeness to step on W/O	0.00				(413)			
QC	<b>Memo</b>	0.00							
Quality Control									
150 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	<b>Memo</b>	2:45							
Powder Coating	START TIME: 3200F <input type="checkbox"/> FINISH TIME: 3:15 <input type="checkbox"/> OVEN TEMPERATURE: 13XØ m - 11/10								

W 118439

W/O:		WORK ORDER CHANGES					
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**Work Order ID 74591**

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Page 3

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 10/3/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13  $\phi$  Malhotra  
COUNT MEASURED

170

Identify as per dwg & Stock Location: FP-1

0.00



Packaging

Memo

0.00

Packaging

13  $\phi$  Malhotra

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/12  $\phi$   
MF 11-10-17

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, October 03, 2011 3:57:30 PM

Page 1

Work Order ID: 74591

Parent Item: D3793-1

Parent Item Name: Wearshoe




Start Date: 10/3/2011

Required Date: 10/5/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased		No		100	sf	170.5795	0.5902	7.455158	8		
												B11-10-6	

Location

Loc Qty

Loc Code

MAT020

170.5795

116623

0.2

117550

8.363

117933


45.3442

118400

33.6723

118964

83

  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
110400  
~~110400~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 74591
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3793-1
<b>Inspection Dwg:</b> D3793	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.193	>		V B02	
0.300 x 0.300	+/-0.010	302 x 307	>		V	
1.885	+/-0.010	1.889	>		V	
2.000	+/-0.010	2.000	>		V	
5.00	+/-0.030	5.00	>		T B01	
8.00	+/-0.030	8.00	>		T	
14.00	+/-0.030	14.00	>		T	
20.00	+/-0.030	20.00	>		T	
14.066	+/-0.010	14.066	L		T	
18.983	+/-0.010	18.983	L		T	
23.900	+/-0.010	23.900	L		T	
27.400	+/-0.010	27.400	L		T	
29.400	+/-0.010	29.400	>		T	
32.900	+/-0.010	32.900	>		T	
0.040	+/-0.010	.037	<		V	

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-10-6	<b>Date:</b> 11/10/07	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	08.05.30	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

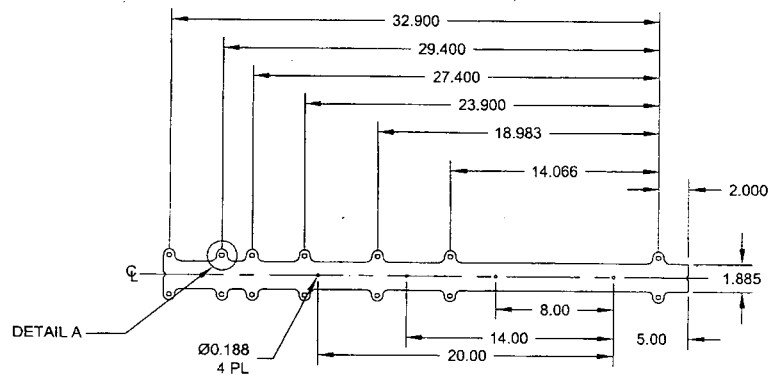
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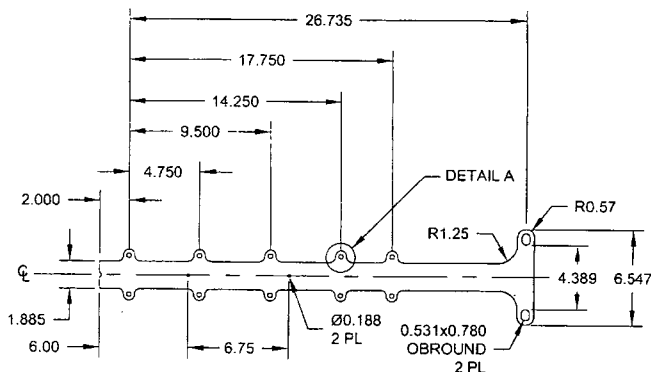
8 7 6 5 4 3 2 1

D

C



**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

0.32  
REF

R31.6

C

C

DETAIL B

**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)

C

C

**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

**RELEASED**  
08-05-23/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

PH 11-10-04  
74591

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	08.05.14
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

8 7 6 5 4 3 2 1

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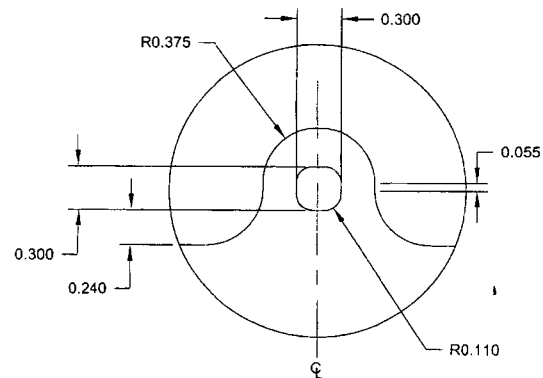
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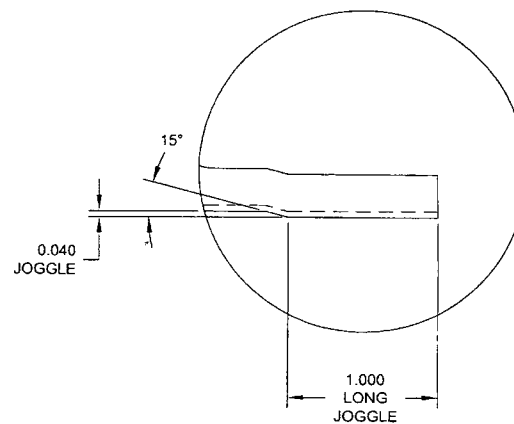
8 7 6 5 4 3 2 1

D

D



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X

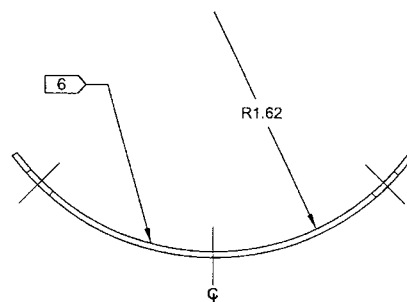
74591

C

C

B

B



**SECTION C-C**  
SCALE 10X

**RELEASED**  
08-05-23/102

A

A

8 7 6 5 4 3 2 1

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
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